

Date: Monday, 08/09/2008 2:50:47 PM
 User: Julie Lecocq

Process Sheet

SPLIT-1

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TUBE
Job Number	: 41890		
Estimate Number	: 11175		
P.O. Number	:	Part Number	: D22825
This Issue	: 08/09/2008 S.O. No. :	Drawing Number	: D2282 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: E
Previous Run	: 39717	Material	:
Written By	:	Due Date	: 30/10/2008
Checked & Approved By	: <u>JUL 08.9.08</u>	Qty:	42 Um: Each
Comment	: Est Rev:A Removed from 9 Digit 05-12-02 JLM		
	: EstRev:B Now on Doosan Lathe 08-06-05 JLM		
	: Verified By:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304R0750	304 SS Roundbar .750
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Comment: Qty.: 0.1891 f(s)/Unit Total: 18.9063 f(s)
 Material: AISI 304 Stainless Steel Ø0.750(M304R0.750)
 Batch M109421

ml 08/10/22

42

2.0	DOOSAN LATHE	DOOSAN LATHE
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Comment: DOOSAN LATHE
 1-Turn as per Dwg D2282 and Folio FA189

2-Deburr

ml 08/10/22

42

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 08/10/22

42

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

ISP 08/10/22

(42)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 25

8/10/22

26 Stone

(42x) SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Proc Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 08/09/2008 2:50:47 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 41890

Part Number: D22825

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/22 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08.10.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 41890
Description: Handle Tube		Part Number: D2282-5
Inspection Dwg: D2282	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.17	+/-0.030	2.165"	✓			
R0.063	+/-0.010	R.063"	✓			
0.063	+/-0.010	.063"	✓			
0.125	+/-0.010	.125"	✓			
0.090 x 45°	+/-0.010	.090" x 45°	✓			
R0.350	+0.010/-0.000	R.350"	✓			
0.158	+/-0.010	.154"	✓			
Ø0.386	+0.005/-0.000	Ø.390"	✓			
Ø0.700	+/-0.010	Ø.700"	✓			

Measured by: J.F.	Audited by: JTP	Prototype Approval:	N/A
Date: 08/10/15	Date: 08/10/22	Date:	N/A

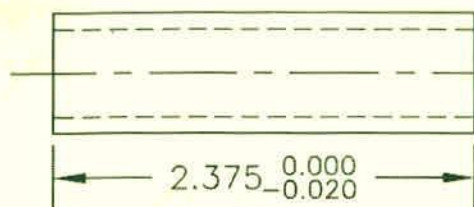
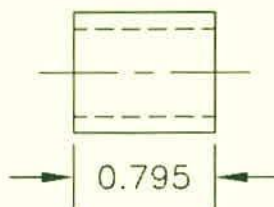
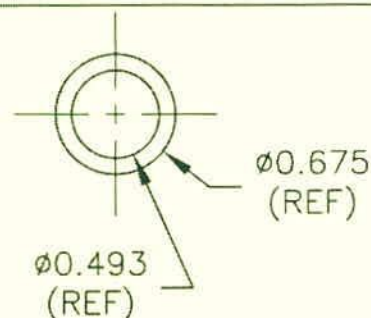
Rev	Date	Change	Revised by	Approved
A	03.11.11	New Issue P/O D350-615-041	KJ/RF	
B	05.04.19	Dimensions & tolerances changed	KJ/JLM	
C	06.03.15	Dimensions & tolerances revised per Dwg Rev E	KJ/JLM	
D	07.11.26	Ø0.700 dimension added	KJ/EC/DD	

DART

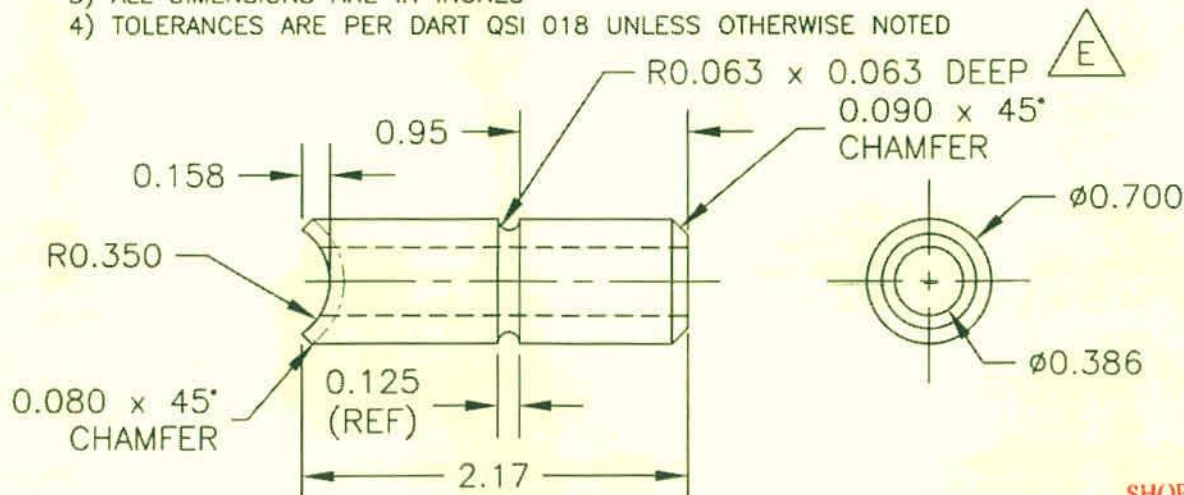
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

RELEASED
[Signature]

05/09/16

**D2282-3****D2282-7****D2282-3/-7 TUBE:**

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2282-5****D2282-5 STEM:**

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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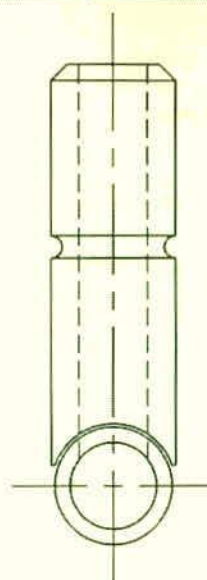
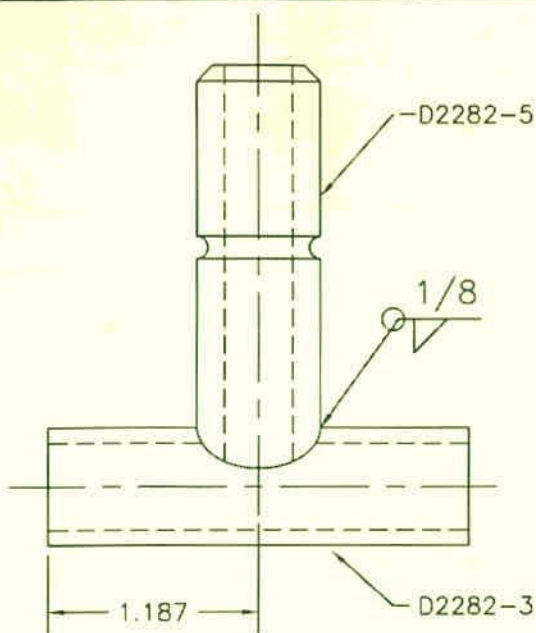
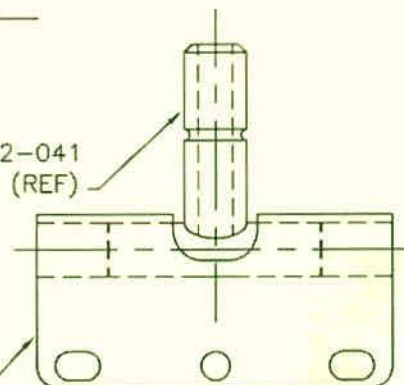
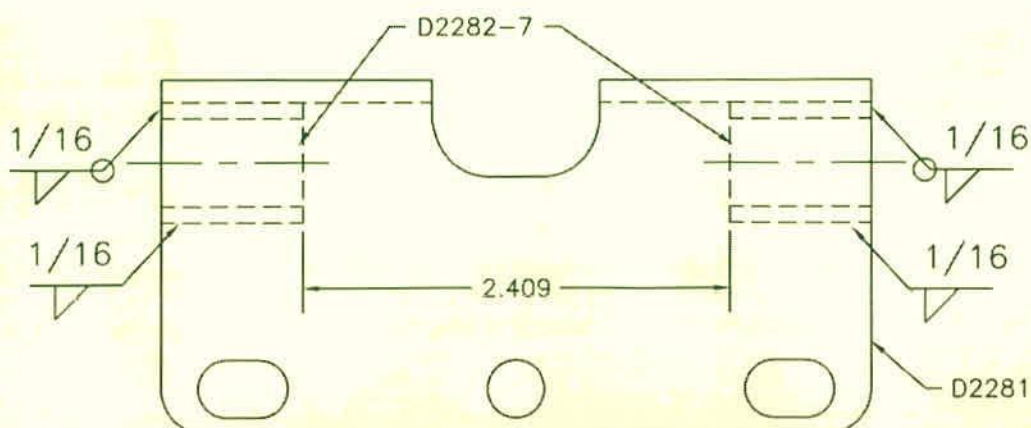
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DART

DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1

D2282-041
(REF)**GENERAL ASSEMBLY**
SCALE 1:2**D2282-043 SADDLE ASSEMBLY**
WELD ASSEMBLY PER DART QSI 004

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